

Work Order ID 68921

Monday, April 25, 2011 2:17:23 PM



Page 1

Item ID: D3028-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud

Start Date: 4/25/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 10.00



Customer:

Reference:

11-04-25

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3028

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn blank per Dwg D3028 and FA263

*SL 11/4/25**10* *φ*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SL 11/4/25**10* *φ*

120

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Cut groove as per Dwg D3028 and FA

2-Deburr

*SL 11/04/27**10*

Work Order ID 68921

Monday, April 25, 2011 2:17:23 PM

Page 2

Item ID: D3028-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Stud

Start Date: 4/25/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC2- Inspect parts off machine FAI/FAIB

0.00

JL 11/04/27



QC

Memo

0.00

Quality Control

140

QC8- Inspect parts - second check

0.00

B.A 11/04/27



QC

Memo

0.00

Quality Control

10 0

150

Outsource process-Cadplate per QSI017 4.1.9.1

0.00



Outsource3

Memo

0.00

Outsource process - Cad plate

Issue P/O: 13956
Finish : Cadmium plate per QQ-P-416F Class I, Type II
Material release note is required.

CL 11/04/27 10

Work Order ID 68921

Monday, April 25, 2011 2:17:23 PM

Page 3

Item ID: D3028-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Stud

Start Date: 4/25/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Sulostor

x10

Memo

0.00

160



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

Identify and Stock

Seq. 175

ST 31

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/2 (10)

11/5/2 sl 100

11/5/3

P/11-05-3

Picklist Print

Page 1

Monday, April 25, 2011 2:17:19 PM

Work Order ID: 68921



Parent Item: D3028-1



Parent Item Name: Stud

Start Date: 4/25/2011

Required Date: 4/29/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPPB 02.09.10 Made on Cobra KJ
IPP C 08.11.06 Added QC6 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750		Purchased	No			110	f	11.9200	0.125	1.315789			
4130 steel RD bar .750"													



3/2 11/4/25

Location

Loc Qty

Loc Code

MAT031

11.92

111823

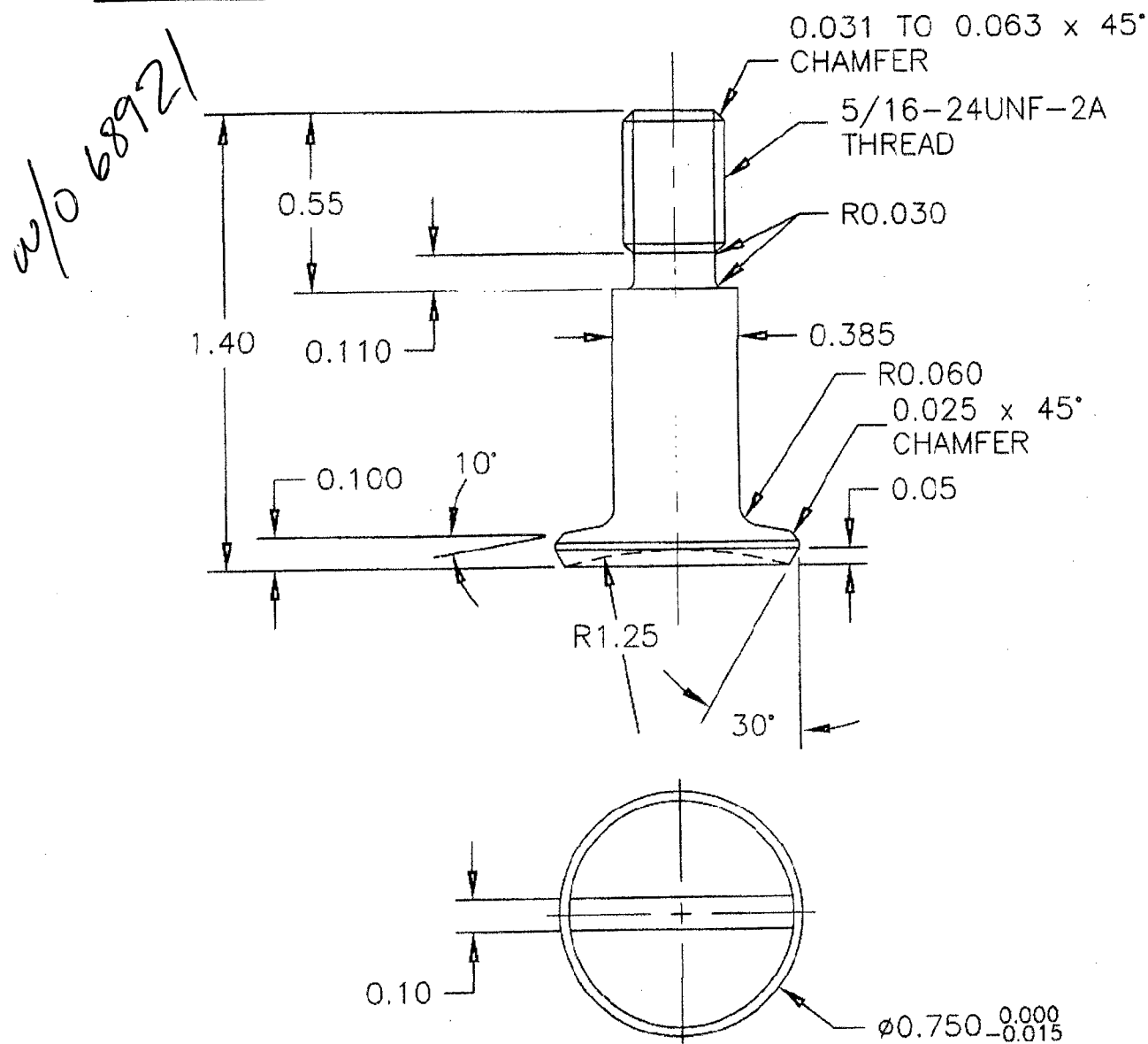
11.92

1.3



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3028	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE STUD	SCALE 2:1
A	01.05.18	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D3028-1:

- 1) POSSIBLE SUPPLIER: NORTHERN AERO INDUSTRIES P/N B83602-1
- 2) MATERIAL: AISI 4130N BAR PER MIL-S-6758 OR AMS 6348/6370/6528
- 3) THREADS PER MIL-S-7742
- 4) FINISH: CADMIUM PLATE PER QQ-P-416F CLASS 1, TYPE II
- 5) ALL DIMENSIONS ARE IN INCHES.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Packing Slip



CADORATH
COATING

Cadorath Coating

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

INVOICE NUMBER:

54594

Sold To:

Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

Ship To:

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #: 13956

Date Received: Apr-28-2011

Terms:

NET 30 DAYS

G.S.T. #:

10071 6547 RT0001

Ship Via:

Ship Date:

Apr-29-2011

Item # Qty P/N & Description

1	8 EA	STUD	S/N B68620
		P/N D3028-1	W/O 104117
2	10 EA	STUD	S/N B68921
		P/N D3028-1	W/O 104118



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13956**

Purchase Order Date 4/27/2011

PO Print Date 4/27/2011

Page Number 1 of 1

Order From :

VC-CAD002

CADORATH COATING
2150 LOGAN AVE.
WINNIPEG, MB R2R 0J2
CA

Contact Name

Vendor Phone

204 633 9420

Vendor Fax

204 633 8033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

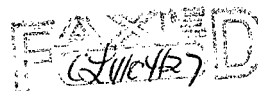
FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

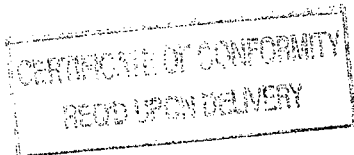


Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	68620	D3028-1 STUD	5/4/2011 Yes	8.00	FedEx PI collect	\$6.9400	\$55.52
		Special Inst: CAD PLATE AS PER DWG D3028 REV.A CADMIUM PLATE AS PER QQ-P-416F CLASS 1, TYPE II					
2	68921	D3028-1 STUD	5/4/2011 Yes	10.00	FedEx PI collect	\$6.9400	\$69.40

Special Inst: AS ABOVE

PO Total:

\$124.92



CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 4/27/2011

**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Apr-29-2011

CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawksbury, ON K6A 1K7

W/O #: 104118
INVOICE #: 54594

**CONTRACT OR
PURCHASE ORDER #**

13956

DESCRIPTION: STUD

QTY 10

P/N # D3028-1

S/N # B68921

**CADMIUM PLATED IAW AMS-QQ-P-416C, TYPE 2 YELLOW, CLASS
1. BAKE HEAT CHART #11-440.**

8/11/05/02

CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.

Approved Inspector:

